

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries






Work Order ID 51087

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Item ID:	D2563	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Step Weldment Assembly					
Start Date:	7/31/09	Start Qty:	4.00		Cust Item ID:	
Required Date:	8/14/09	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		SAD	09-08-04				
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		M.K	09/08/04				
150  Large Fab Large Fab	Large Fab Memo 1-Inspect for foreign object per QSI 024 2-Weld Remainig End as per Dwg D2563 using DT 8343 <input type="checkbox"/> A/R AL ROD Batch: <u>M110130</u> <input type="checkbox"/> 3-Grind	0.00 0.00				<u>4</u>			<u>14 09.08.05</u>

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Required Date:	8/14/09	Req'd Qty:	4.00	Customer:		
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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

170	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

180	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	* Touch up Alodine	0.00							
Powder Coating	Memo	0.00							
	Touch up Alodine then								
	2:30p ~ OVEN TEMPERATURE: 3:00p FINISH								
	TIME: 320°F								

1112-148 09-08-05 X4

2) Scissors
 SEQ 210 → PPP 51086 YX P248/15

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Picklist Print

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Work Order ID: 51087

Parent Item: D2563RevC

Parent Item Name: Step Weldment Assembly


Comments:

Start Date: 7/31/09

Required Date: 8/14/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2244-116RevD1		Manufactured	No			100	Each	61.0000	4.0000			
												

Step Extrusion

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

33733

38023

61

3

58

100

Each

24.0000

8.0000

8/09-07-31

4

D2561RevB

Manufactured

No



Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47177

24

24

100

Each

63.0000

8.0000

8/09-07-31

8

D2564RevB1

Manufactured

No



Mounting Angle

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

45243

47966

63

10

53

8/09-07-31

8

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Parent Item: D2563RevC



Parent Item Name: Step Weldment Assembly

Start Date: 7/31/09

Required Date: 8/14/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2673-34RevB		Manufactured	No			100	Each	35.0000	8.0000			



End Plate



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

36406

35

35

809-01-31 8

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Shop Packet Print

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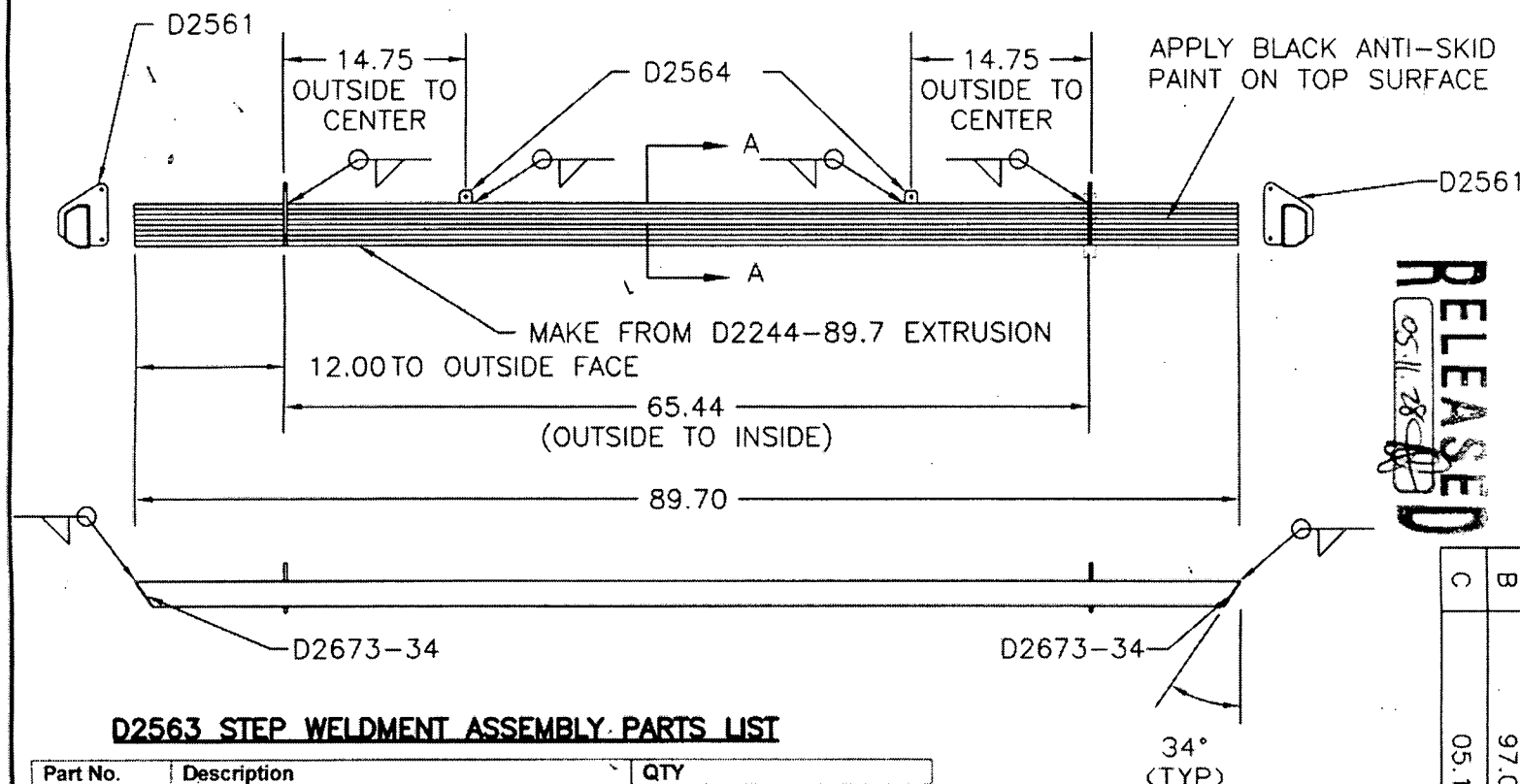
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DART

RELEASED
05.11.28

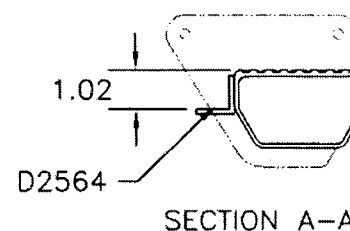
DESIGN	BW	DRAWN BY	<i>fw</i>	DART AEROSPACE LTD
CHECKED	<i>fw</i>	APPROVED	<i>fw</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	DRAWING NO.	D2563	REV. C
		TITLE	STEP WELDMENT ASSEMBLY	SHEET 1 OF 1
		SCALE	1:15	
A	96.04.26	NEW ISSUE		
B	97.05.14	END CAPS CHANGED (WAS D2248)		
C	05.11.14	UPDATE NOTES		



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing



*w/c
5/28/14*

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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